

Date: Monday, 1/7/2008 3:38:43 PM
User: Kim Johnston

ASAP

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 36637		
Estimate Number	: 12784		
P.O. Number	:	Part Number	: D35649
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D3564 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL / MED FAB	Drawing Revision	: D
Previous Run	: 36023	Material	:
Written By	:	Due Date	: 1/21/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>08.01.8</u>		
Comment	: Est Rev: A New Issue 07-03-08 ec Est Rev: B As per Rev C 07-07-09 JLM Est Rev: C As per Rev D 07-09-09 JLM Verified By: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



25.41



Comment: Qty.: 1.1550 sf(s)/Unit Total : 23.1000 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 106653 B 8-1-10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F) *****
Dwg Rev: D B 8-1-10
Prog Rev: D

2-Deburr if necessary B 8-1-10

22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-1-10



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/01/11 (22)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT 8155 and DT 8179

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

DB 08/01/17 22

08/01/17 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36637

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/01/18 (22)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M106834
M106390

FC 08/01/22

(22)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-22 (22)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-22 (22)

10.0

POWDER COATING

POWDER COATING



M106442



(22X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-1 08/01/24

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-25

(22)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



(22X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-P 18

M-1 08/01/25

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/01/25

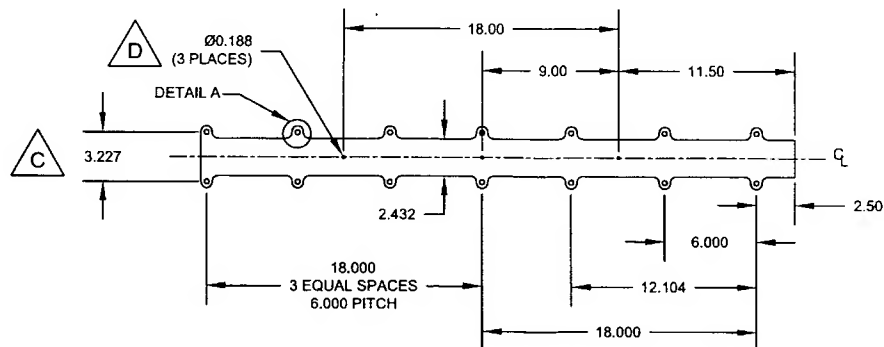
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

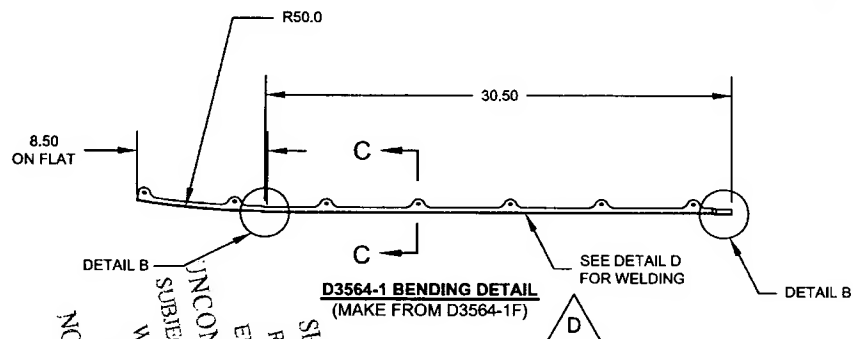
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

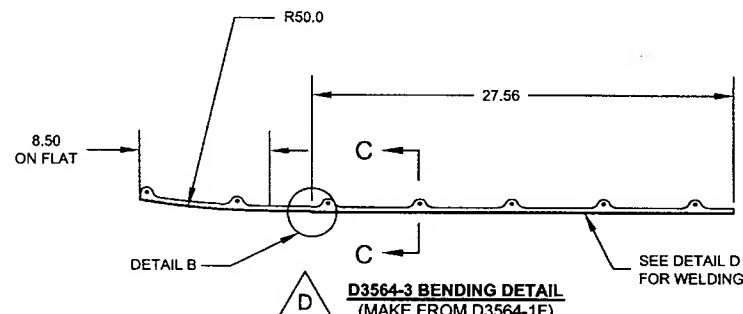
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

RELEASED

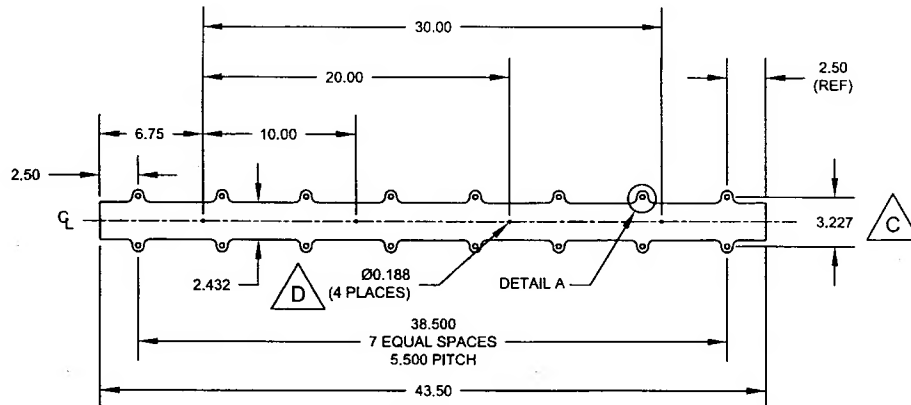
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

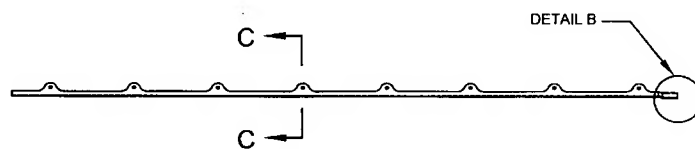
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3564
REV. D
SHEET 1 OF 3
TITLE WEARSHOE
SCALE 1:8

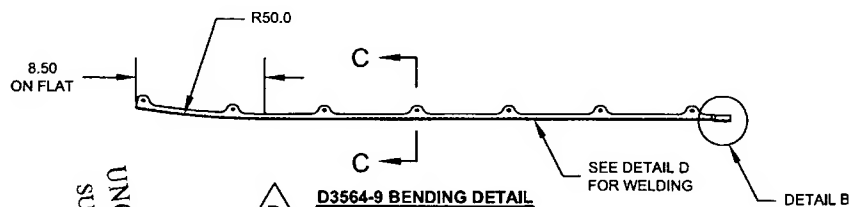
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D3564-5F FLAT PATTERN

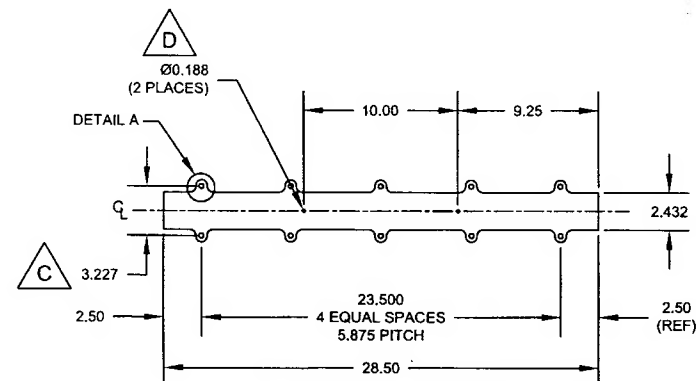


D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

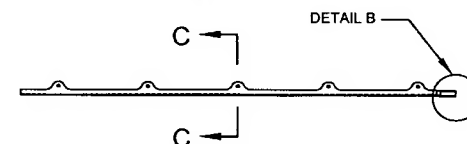


D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

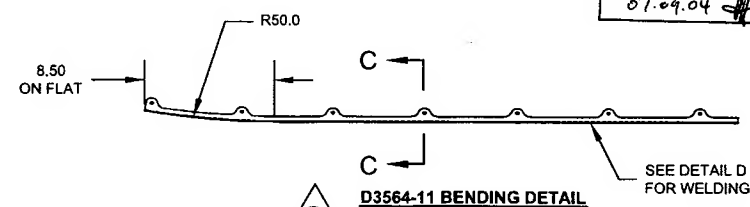
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SHOP COPY



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

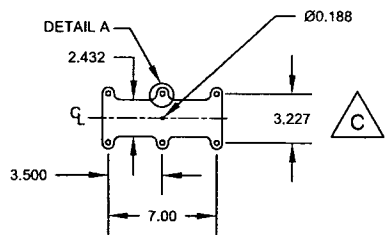


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

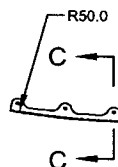
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07.09.04

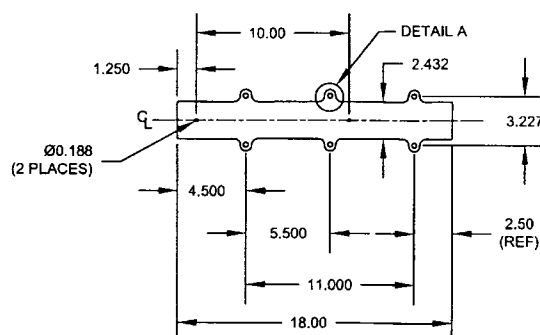
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DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	21	D3564	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
DE APPR.	SH	WEARSHOE	1:8
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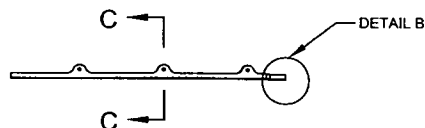
D3564-13F FLAT PATTERN



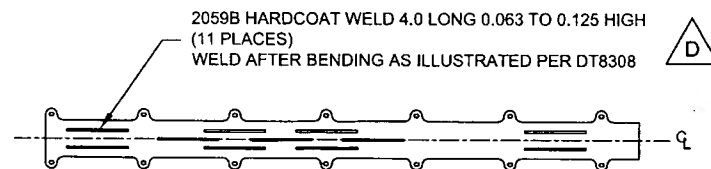
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



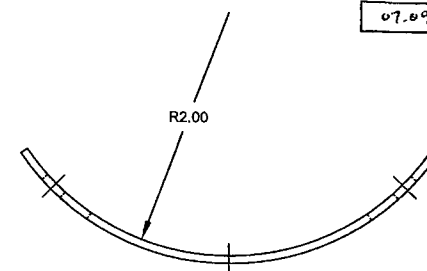
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



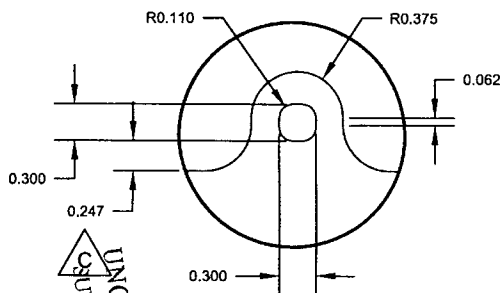
DETAIL D
(D3564-1/-3/-8/-11 WELDING DETAIL)

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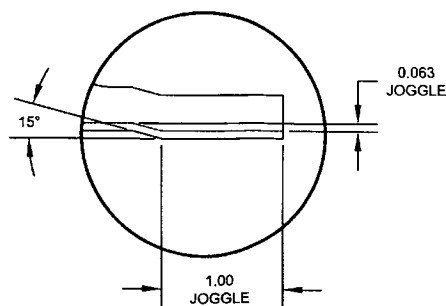
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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WORK ORDER
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SUBJECT TO AMENDMENT

DART AEROSPACE LTD		Work Order:	36637
Description: WEAR PAD		Part Number:	D3564-9
Inspection Dwg: D3564-9 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST


X

First Article

Prototype

[illegible]

Measured by:	HR
Date:	8-1-10

Audited by:	
Date:	20/02/11

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	